

Maintenance Table Spiral Conveyor

(M) Mandatory
(A) Advised



Maintenance table	Every working day	After first 200 hours of operation	Every month of operation	Every 6th month of operation	Every 12 months of operation	Depending on operating conditions every 5 years (synthetic oil)
Clean Spiral Conveyor for dust and debris (see Cleaning Instructions)			A			
Check Spiral Conveyor on strange or loud noises and unusual movements of parts, gear motor, bearings and shafts	M					
Check and tighten all fastener (bolts and nuts)		M	A			
Ensure that the bolts of the mounting frames are tensioned on 49nM (+-Nm) (*) only applicable for Spiral Conveyors without support legs		M		M		
Inspect slats and carriers and replace any damaged parts			A			
Check chain tension and adjust if necessary		M	A	M	M	
Lubricate conveyor chain *1				A		
Check overload and automatic chain tension devices for functionality					M	
Check for wear of chain and sprockets				A	M	
Check gearboxes and fill up oil if required				A		
Check complete spiral conveyor and change defect parts				A		
Replace oil of the gear units						M
Check if warning stickers are still visible, clean or replace if necessary			A			
Check if there are no loose bolts			A			

*1: Depending on the circumstances the conveyor chain needs to be lubricated. Frequency depends on local environment and circumstances. Please note that the chain only needs to be slightly lubricated, it should definitely not soak in oil. For wash down machines the frequency of lubricating needs to be increased in most cases. The required frequency is very dependent on the washing procedures. It is required to check the chain condition often to ensure that no rust will occur on the chain. In all cases a rusted chain and/or sprocket wheels will not be considered as warranty.

* These maintenance guidelines are based on an average of 10 hour of operation per day for 5 days per week.

The Royal APOLLO GROUP consists of:
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